

27/11/2008 2:37:04 PM

Process Sheet

: CU-DAR001 Dart Helicopters Services
 : 43826
 : 12282
 P.O. Number :
 This Issue : 27/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 28731
 Written By :
 Checked & Approved By : JUD 08-11-27
 Comment : Est D 03.05.30 Reformat; Incorporated D2672B IPP KJ/RF
 Est Rev:E New Manufacturing Method 08-10-29 JLM Verified
 By:EC

Drawing Name : BEARPAW INSTALLATION KIT (13"X24" BENT)
 Part Number : D206559025
 Drawing Number : D2672 REV B1
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 04/12/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

~~Issue Traveler~~

Note: (1) D206-559-025 Kit consists of Qty (2) D2672B

~~Dwg not required~~

Photocopy bluefile and create labels per PPP D206-559-025 CHG005

for JUD 08/12/03

S 09/01/12

2.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------



Comment: MFG ENGINEERING

Program Batch Number

for 08.11.28

3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 4.8300 sf(s)/Unit Total : 9.6600 sf(s)

Material: Black UHMW 1"

Cut 2 blanks per (1) D206-559-025 Kit

Material: Black UHMW 1"

(MUHMWB10)

Batch: 109186 1B 8-12-3

(4)

4.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut Blank as per File D2672_BLANK

1B 8-12-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:37:04 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #: Machine Or Operation: Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA791 and Dwg D2672. Identify as D2672

3-Deburr

M.A

09/01/09

(4)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A

09/01/09

(4)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JP 09/01/09

(4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

(Note: D2672B is on the BOM as material from step 3)

9.0

D2182B

Rubber Cushion



Comment: Qty.: 2.5000 f(s)/Unit Total: 5.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

1340737

SH

10.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

1342099

9/1/09

SP

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/1/12		SKAP D218213 0.50	SP		1 S inches		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION KIT (13"X24" BENT)

Job Number: 43826

Part Number: D206559025

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	D2438	Clamp
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
6	D2438	Clamp	B41428

SP

12.0	D2529	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
12	D2529	Washer	B42408

SP

13.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
12	AN4-15A	Bolt	M109148

SP

14.0	AN417A	Bolt
------	--------	------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
12	AN4-17A	Bolt	M109061

SP

15.0	AN960JD416	Washer
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
24	AN960JD416	Washer	M109249

9/1/12

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #: Machine Or Operation: Description :

16.0 MS21042L4 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4)

M108443

M107499

M105054

9/1/12

2x

SP

17.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 09/01/12

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-559-025

Identify and Stock

Location: 12

Rev B

9/1/12

50

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/13

Job Completion



MF 09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43820
Description: Bearpaw		Part Number: D2672
Inspection Dwg: D2672	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.053x45°	✓			
B	12.750	+/-0.030	12.750	✓			
C	4.250	+/-0.010	4.250	✓			
D	2.000	+/-0.030	2.002	✓			
E	9.000	+/-0.010	8.996	✓			
F	0.375	+/-0.030	0.375	✓			
G	9.000	+/-0.010	8.996	✓			
H	Ø0.260	+0.005/-0.000	Ø0.260	✓			
I	Ø0.93	+/-0.030	Ø0.925	✓			
J	0.300	+0.030/-0.000	0.305	✓			
K	0.625	+/-0.030	0.625	✓			
L	0.063 x 45°	+0.030/-0.010	0.053x45°	✓			
M	0.250	+/-0.010	0.248	✓			
N	5.500	+/-0.030	5.499	✓			
O	R0.250	+/-0.030	R0.250	✓			
P	0.200	+/-0.030	0.203	✓			
Q	0.25 x 45°	+/-0.030	0.253x45°	✓			
R	0.950	+0.030/-0.010	0.952	✓			
S	0.375	+/-0.010	0.376	✓			

Measured by: H.A	Audited by: DJT	Prototype Approval: N/A
Date: 09/01/09	Date: 09/01/09	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
KE	KE	DRAWING NO.	D2672	REV. B
CHECKED M	APPROVED V	DATE	98.05.19	SHEET 1 OF 2
		TITLE	BEARPAW	SCALE 1:5
A	97.04.08	NEW ISSUE		
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50		
B1	02.10.22	$\phi 0.93$ WAS $\phi 0.75$		

ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)



$\phi 0.260$ (TYP)
 ~~$\phi 0.75$ C'BORE~~ $\phi 0.93$ C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)

EFFECTIVE

DEOS

RELEASED
98.06.17 KS

9143	
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FLAT PATTERN

BEND AFTER MACHINING
(D2672B ONLY)

D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

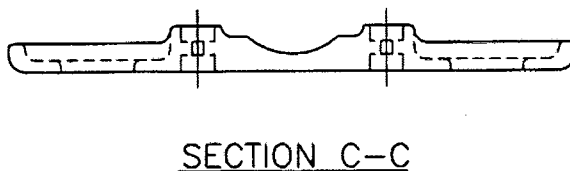
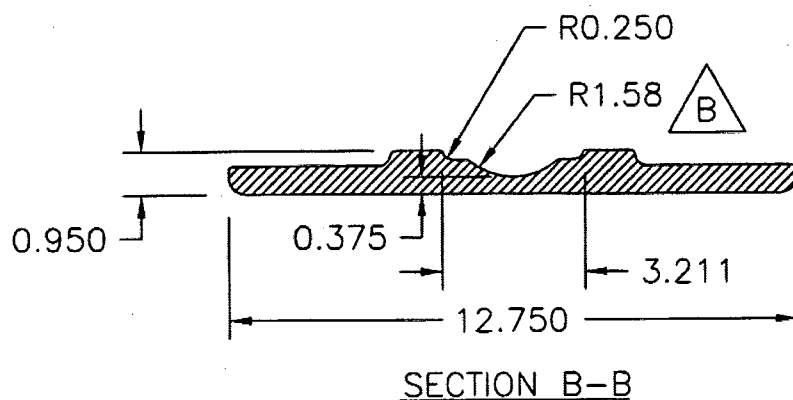
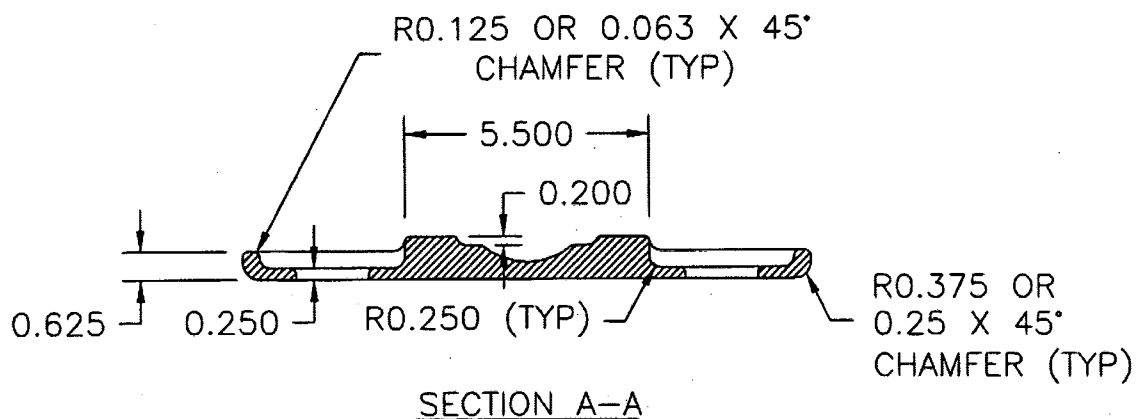
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ATTENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13820



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>mm</i>	APPROVED <i>S</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



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WORK ORDER
NO. 43826